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Grundhalter und Stechhaltestücke
Basic Toolholder and grooving toolholder

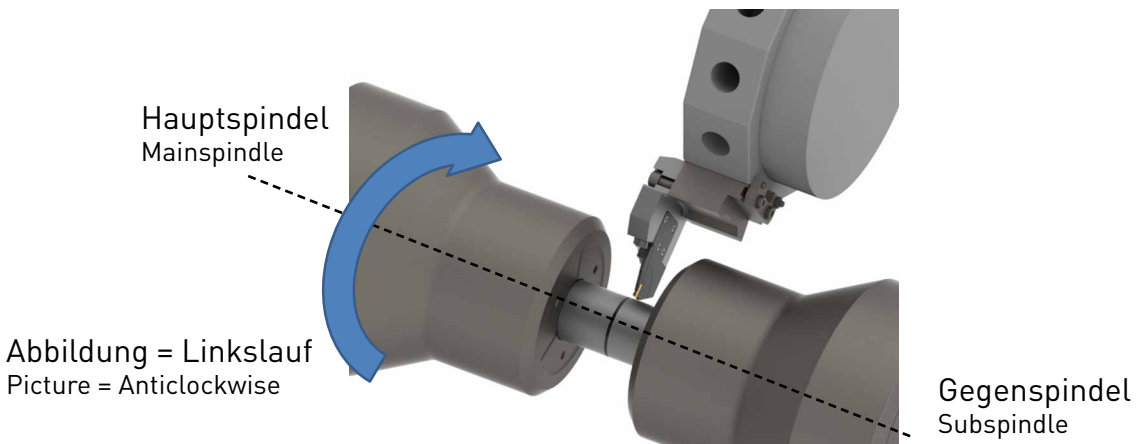
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Mehrspindler INDEX
Multi-spindle machine INDEX

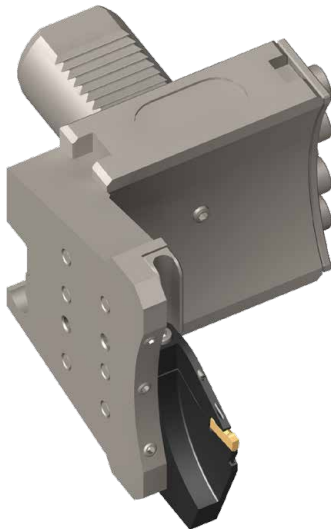
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Mehrspindler Schütte
Multi-spindle machine Schütte

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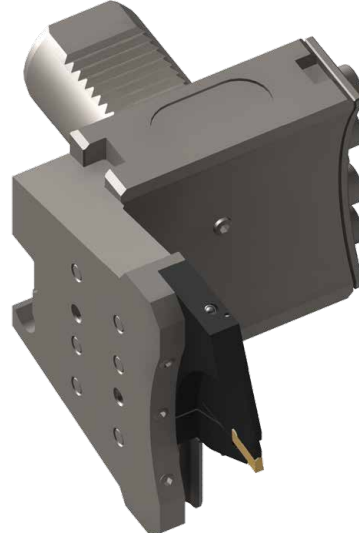
Abstechen an der Gegenspindel im **Linkslauf**
Parting off on the subspindle in **anti-clockwise rotation**



Stechhaltestück
Grooving toolholder
960.I.0.845...

Kassette
Cassette
RNK100.0845...

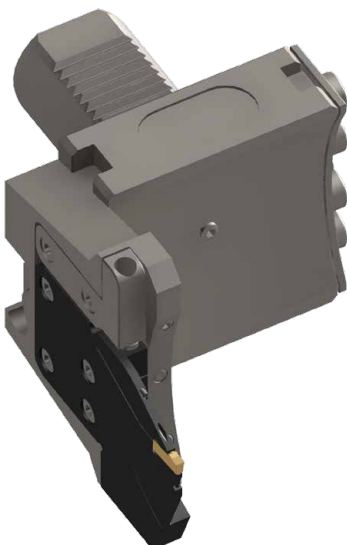
Abstechen an der Gegenspindel im **Rechtslauf**
Parting off on the subspindle in **clockwise rotation**



Stechhaltestück
Grooving toolholder
960.I.0.845...

Kassette
Cassette
LNK100.0845...

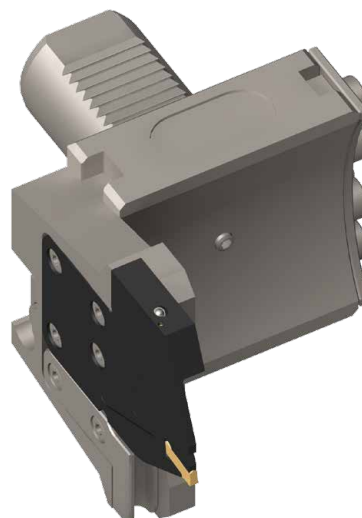
Abstechen an der Hauptspindel im **Linkslauf**
Parting off on the main spindle in **anti-clockwise rotation**



Stechhaltestück
Grooving toolholder
960.A.0.845...

Kassette
Cassette
LNK100.0845...

Abstechen an der Hauptspindel im **Rechtslauf**
Parting off on the main spindle in **clockwise rotation**



Stechhaltestück
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960.A.0.845...

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Grundhalter Basic toolholder	
BMT-Größe festlegen Select size BMT	BMT40
Auswahl Grundhalter Select basis toolholder	960.BMT40.CO.00101
Maß notieren Notice dimension	$l_2 = 9 \text{ mm}$
Stechhaltestück Grooving toolholder	
Außenliegende Kassette External cassette	960.A....
Innenliegende Kassette (höhere Bauform) Internal cassette (higher construction)	960.I....
Auswahl Stechhaltestück Select grooving toolholder	960.I.0.845.0003.IK
Ermittlung der Referenzlänge, Maß notieren Determining the reference length, Notice dimension	
Grundhalter 960.BMT40... ($l_2 = 9 \text{ mm}$) Stechhaltestück 960.I...0003 ($l_2 = 80,5 \text{ mm}$) Basic toolholder 960.BMT40... Grooving toolholder 960.I...0003	$l_g = l_2 9 + l_2 80,5 \text{ mm} = 89,5 \text{ mm}$ $f = 66,8 \text{ mm}$
Kassette Cassette	
Vorgaben Dimensions	Stangen-Ø 65 mm, Breite 3 mm bar diameter 65 mm, width 3 mm
Auswahl Kassette Select cassette	LNK100.0845.34.4.73.IK
Maß notieren Notice dimension	$l_k = 46 \text{ mm}$

Berechnung Gesamthöhe Halter Calculation of total height for toolholder	Werkzeugdaten Tool data	
$l_g 89,5 \text{ mm} + l_k 46 \text{ mm} = 135,5 \text{ mm}$	x	z
	$r = 135,5 \text{ mm}$	$f = 66,8 \text{ mm}$
	$\varnothing = 271,0 \text{ mm}$	

Berechnung Umlaufdurchmesser Spannmittel
Calculation of swing diameter clamping device

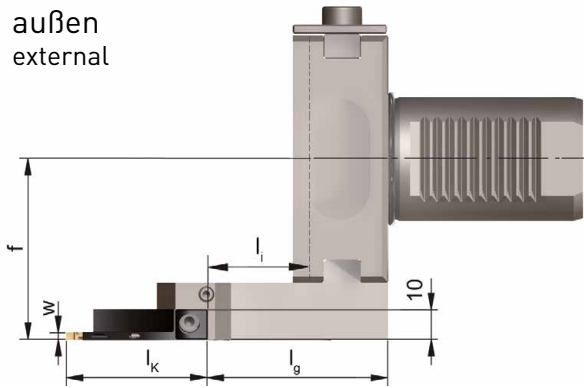
$135,5 \text{ mm} - l_1 (27 \text{ mm}) = 108,5 \text{ mm}$ ergibt einen Umlaufdurchmesser von max. 217 mm
 $135,5 \text{ mm} - l_1 (27 \text{ mm}) = 108,5 \text{ mm}$ results in a maximum circular diameter of 217 mm

Ermittlung der Referenzlänge

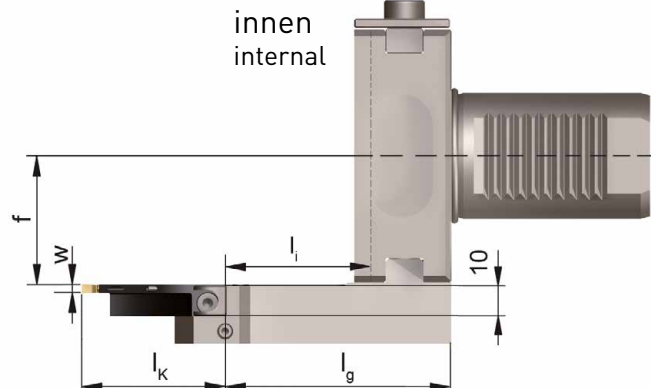
Determining the reference length



außen
external



innen
internal



$$l_K \text{ (Kassettenmaß)} + l_g \text{ (} l_2 \text{ Stechhaltestück + } l_2 \text{ Grundhalter)}$$
$$l_K \text{ (Length of cassette)} + l_g \text{ (} l_2 \text{ Grooving toolholder + } l_2 \text{ Basic toolholder)}$$

Abbildung VDI
Picture VDI

Grundlegende Hinweise

Bitte max. Schwenkkreis- \emptyset des Maschinenherstellers beachten.
Umlauf- \emptyset von Spannfutter zum Abstechhalter prüfen.

Basic Recommendations

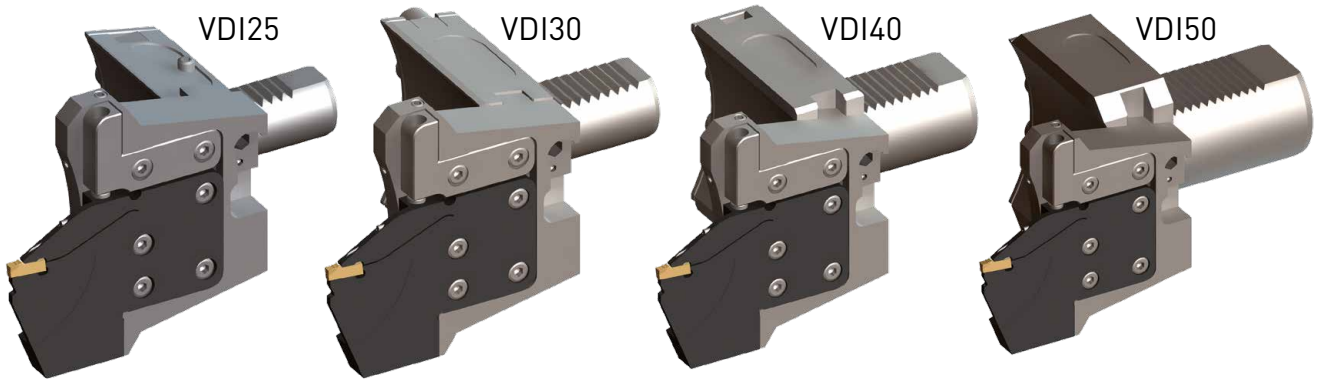
Please note the max. swing circle \emptyset of the machine manufacturers.
Check rotation \emptyset of the chuck to the toolholder.

Übersicht 845 Kassetten + VDI Grundhalter

Overview of cassettes 845 + basic toolholder VDI



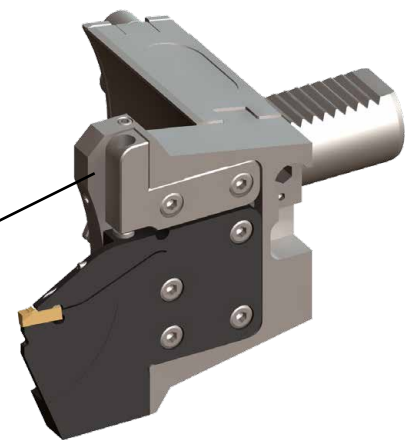
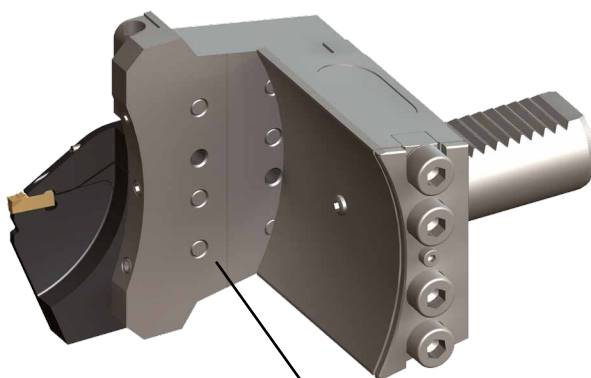
VDI-Halter für alle Größen - 1 Stechhaltstück für alle Größen
1 Grooving toolholder fits all basic VDI toolholders



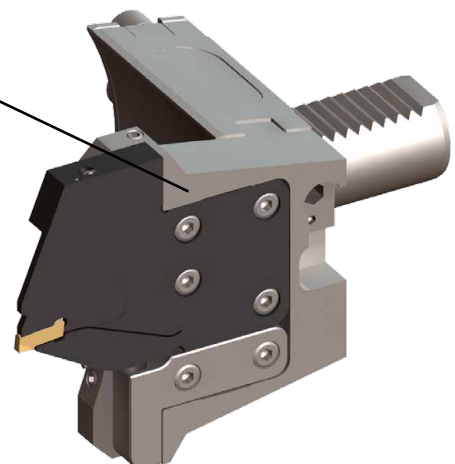
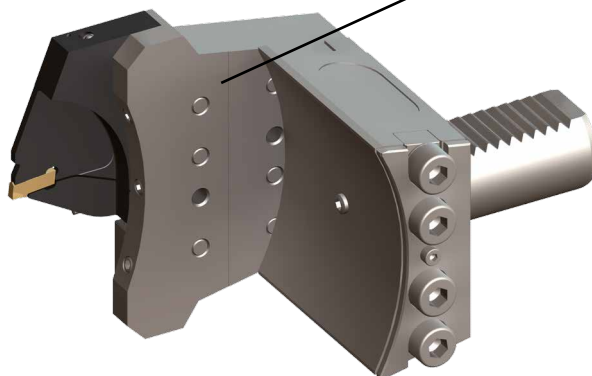
1 Grundhalter + 1 Stechhaltstück = 4 Möglichkeiten des Zusammenbaus
1 Basic toolholder + 1 Grooving toolholder = 4 possibilities of assembling

Links - Normallage
Left - normal position

Rechts - Normallage
Right - normal position



Identisches Stechhaltstück
Identical grooving toolholder



Links - Überkopf
Left - overhead position

Rechts - Überkopf
Right - overhead position

Sternrevolver
Star turrets

Scheibenrevolver
Turrets



960.BMT...



960.MAZ...



960.VDI..C...

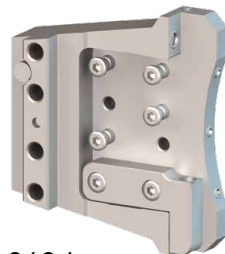


960.VDI.30.B...
960.VDI.40.B...

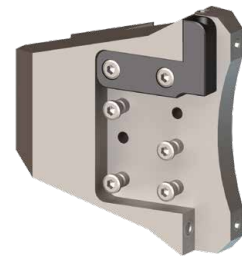
960.VDI.50.B...



960.A...



960.I...



960.Q.0.845.0000.IK

960.Q.0.845.0001.IK

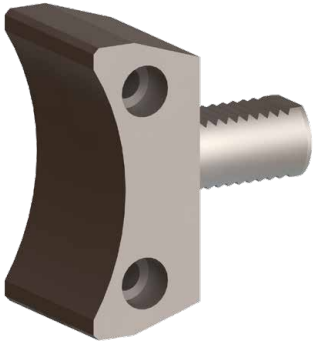


RNK100.0845...

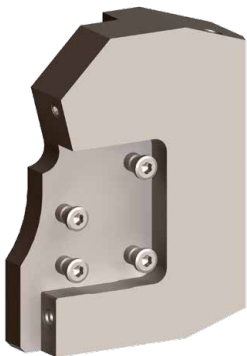


LNK100.0845..

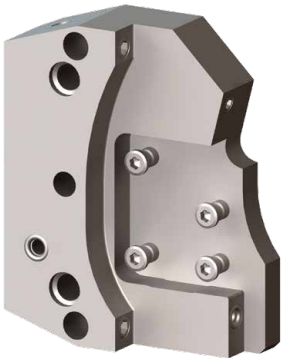
für Traub TNC 42/65
for Traub TNC 42/65



77...



R/L991.X842...R.IK



R/L991.X842...L.IK

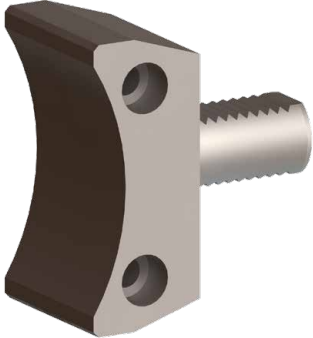


RNK...0842...



LNK...0842...

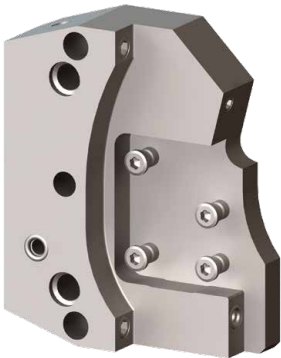
für Traub TNC 42/65
for Traub TNC 42/65



77...



R/L991.X842...R.IK



R/L991.X842...L.IK

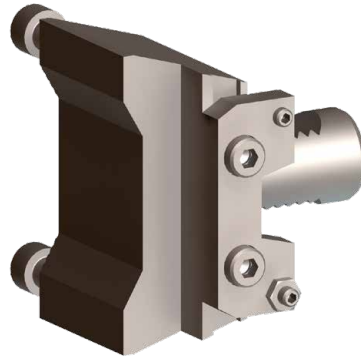


RNK...0842...

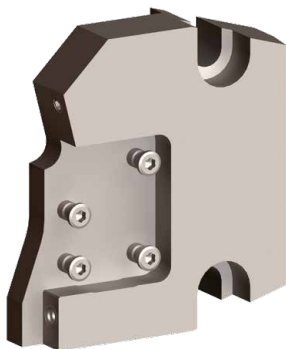


LNK...0842...

für Traub und Index
for Traub and Index



W13... / W14...



R/L990.X845...R.IK



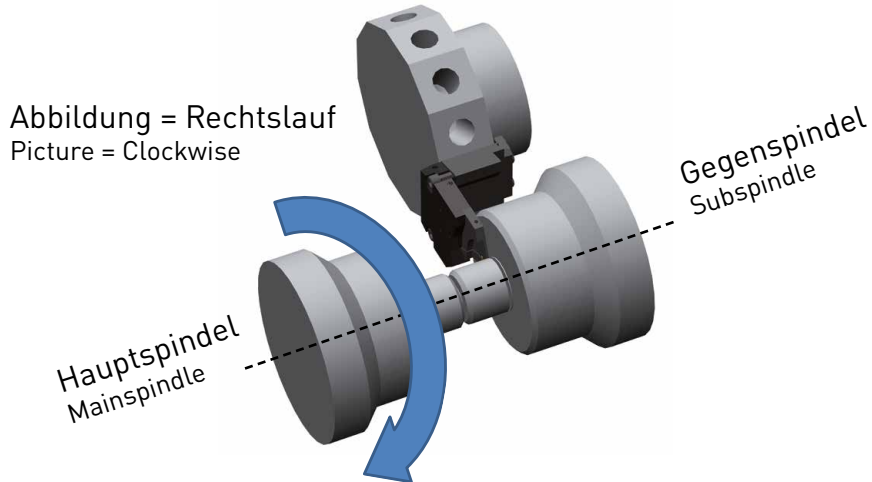
R/L990.X845...L.IK



RNK100.0845...



LNK100.0845..



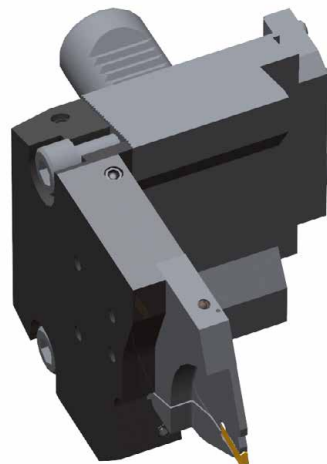
Abstechen an der Gegenspindel im
Linkslauf
 Parting off on the subspindle in
anti-clockwise rotation



Stechhaltestück
 Grooving toolholder
 L990.X845...R.IK

Kassette
 Cassette
 RNK100.0845...

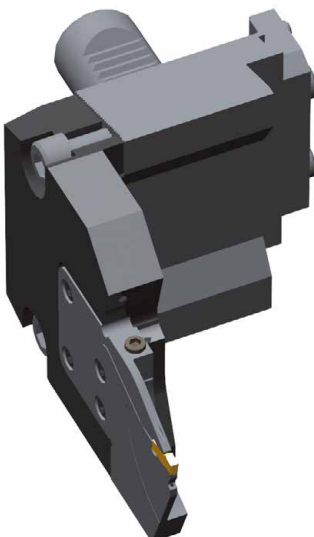
Abstechen an der Gegenspindel im
Rechtslauf
 Parting off on the subspindle in
clockwise rotation



Stechhaltestück
 Grooving toolholder
 R990.X845...L.IK

Kassette
 Cassette
 LNK100.0845...

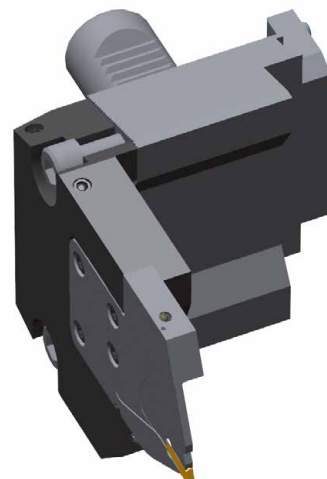
Abstechen an der Hauptspindel im
Linkslauf
 Parting off on the mainspindle in
anti-clockwise rotation



Stechhaltestück
 Grooving toolholder
 L990.X845...L.IK

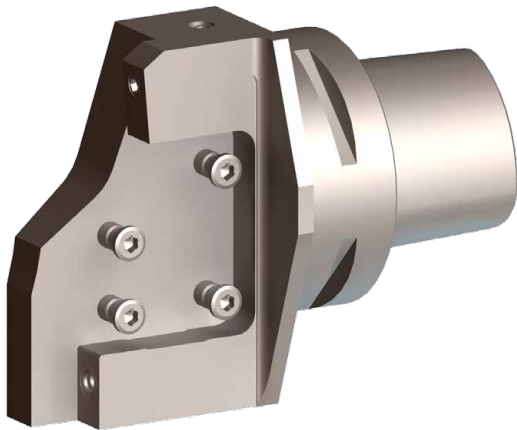
Kassette
 Cassette
 LNK100.0845...

Abstechen an der Hauptspindel im
Rechtslauf
 Parting off on the mainspindle in
clockwise rotation

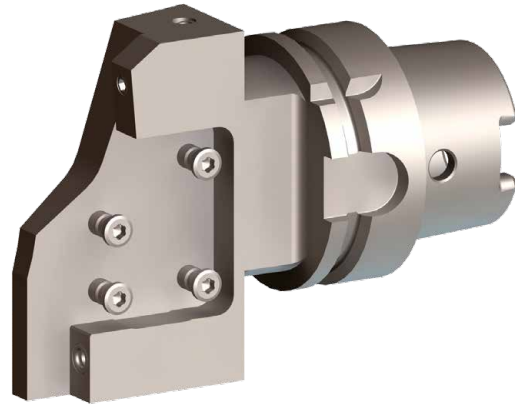


Stechhaltestück
 Grooving toolholder
 R990.X845...R.IK

Kassette
 Cassette
 RNK100.0845...



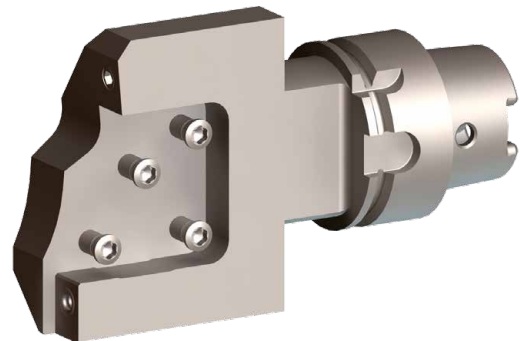
C3.../C5.../C6...



HSKT63...



L/RNK...0842...
L/RNK...0845...



HSKT40...

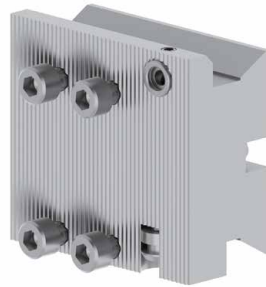


L/RNK100.0842...

für INDEX
for INDEX



W1250031



W8900015



R/L940.X842...R.IK



R/L940.X842...L.IK

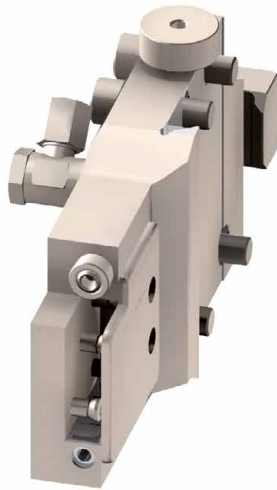


RNK100.0842...

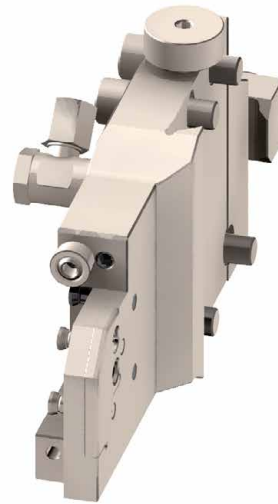


LNK100.0842...

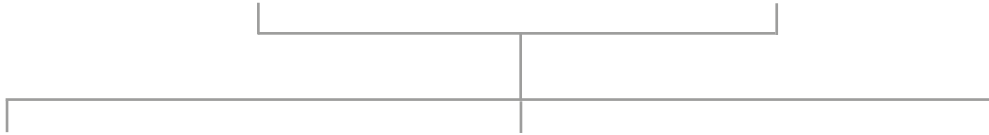
für INDEX
for INDEX



R968...



L968...



R/LNK100.0842...



R/LK842.SD...



R/LK842.SV...

für INDEX-Mehrspindler
for multi-spindle machine INDEX



MS52



MS32 - MS40



MS16 - MS22

für Schütte Mehrspindler
for multi-spindle machine Schütte



für Kasette System 842
for cassette system 842



für Kasette System 840
for cassette system 840



für Klemmhalter mit Quadratschaft
for toolholder with square shank